

Derev 57045

Work Order ID 54214

December 03, 2009 12:47:58 PM



Page 1

Item ID: D3467-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Shroud Assembly

Start Date: 12/03/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/10/2009 Req'd Qty: 1.00



Customer:

Reference: Return 2009 / RA109117

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date: 02-12-03

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3467

Rev C

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Part is from D206-746-011 B42786 kit, & was found incomplete by the customer. Fully assemble as per this w/o. Also see NCR09-101

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

120

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per the dwg for completion.

Mark the un-necessary hardware as N/A if not required & initial. Only record the qty's necessary as well

1 02-12-03

ES 10/03/10 @

ES 10/03/10 @

2000-2001

2002-2003

2004-2005

2006-2007

2008-2009

2010-2011

2012-2013

2014-2015

2016-2017

2018-2019

2020-2021

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2110-2111

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2208-2209

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2244-2245

2246-2247

2248-2249

2250-2251

2252-2253

2254-2255

2256-2257

2258-2259

2260-2261

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2494-2495

2496-2497

2498-2499

2500-2501

2502-2503

2504-2505

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Work Order ID 54214

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Page 2

Item ID: D3467-041

Revision ID: C

Item Name: Shroud Assembly

Start Date: 12/03/2009 Start Qty: 1.00

Required Date: 12/10/2009 Req'd Qty: 1.00

Reference: Return 2009 / RA109117

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Solorin

Memo

0.00

(XL)

140



Packaging

Packaging

Identify as per dwg & Stock Location: 5157

0.00

Memo

0.00

10-3-11 54 (12)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Not all hardware has been pulled. Only what was necessary to complete the assembly.
J.M.

MF 10-3-12

1.1

1.2

1.3

1.4

1.5

1.6

1.7

1.8

1.9

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1.42

Picklist Print

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Page 1/2

Work Order ID: 54214

Parent Item: D3467-041RevC

Parent Item Name: Shroud Assembly

Comments:

Start Date: 12/03/2009

Required Date: 12/10/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3467-043RevC Manufactured

No

100

Each

2.0000

1.0000



Fwd Plate Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

34079

2

D3467-045RevC

Manufactured

No

100

Each

0.0000

1.0000



Baffle & Deflector Assembly

D3467-048RevC

Manufactured

No

100

Each

1.0000

1.0000



Cover Plate Assembly RH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

1

43971

1

NAS679A3

Purchased

No

100

Each

53.0000

8.0000



NUT SELF LOCK

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

100396

3

110180

50

Ep 10/03/10

Ep 10/03/10

N/A before or on B 412786 for reference

Ep 10/03/10
B56781 (12)

Ep 10/03/10

8

Picklist Print

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Page 2 / 2

Work Order ID: 54214

Parent Item: D3467-041RevC

Parent Item Name: Shroud Assembly


Comments:

Start Date: 12/03/2009

Required Date: 12/10/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960-10  Washer		Purchased	No			100	Each	8,628.000	18.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

8628

19356

200

5519

8428

100

Each

0.0000

1.0000

D3467-047RevC

Manufactured

No



Cover Plate Assembly LH

AN3-3A

Purchased

No



Bolt

B56780 (P)

100

Each

437.0000

18.0000

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

437

111925

7

112314

30

112720

100

113121

200

113226

100

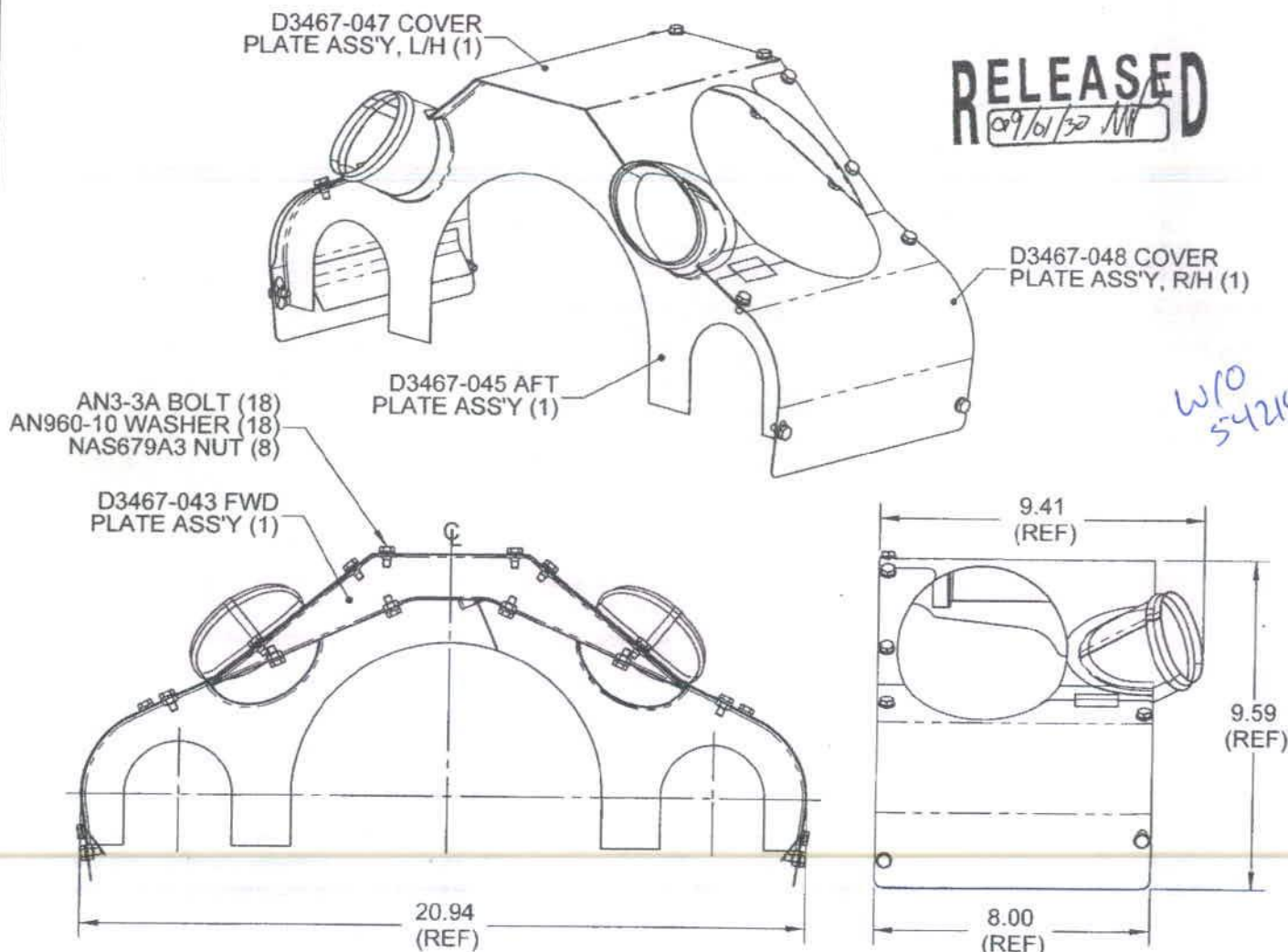
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Shop Packet Print

Page 2

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C SHEET 1 OF 15
DATE 08.12.19	TITLE SHROUD ASSEMBLY		SCALE 1:5
A	05.12.07	NEW ISSUE	
B	06.05.15	$\phi 0.250$ & $\phi 0.203$ WERE $\phi 0.194$; UPDATED D3467-9F/-15F	
C	08.12.19	ADD SLOTS TO D3467-1F (SHT6); CHG TOL ON SHT 7 & 13; MATL SPEC WAS MIL-S-5019	

**D3467-041 SHROUD ASSEMBLY****NOTES:**

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

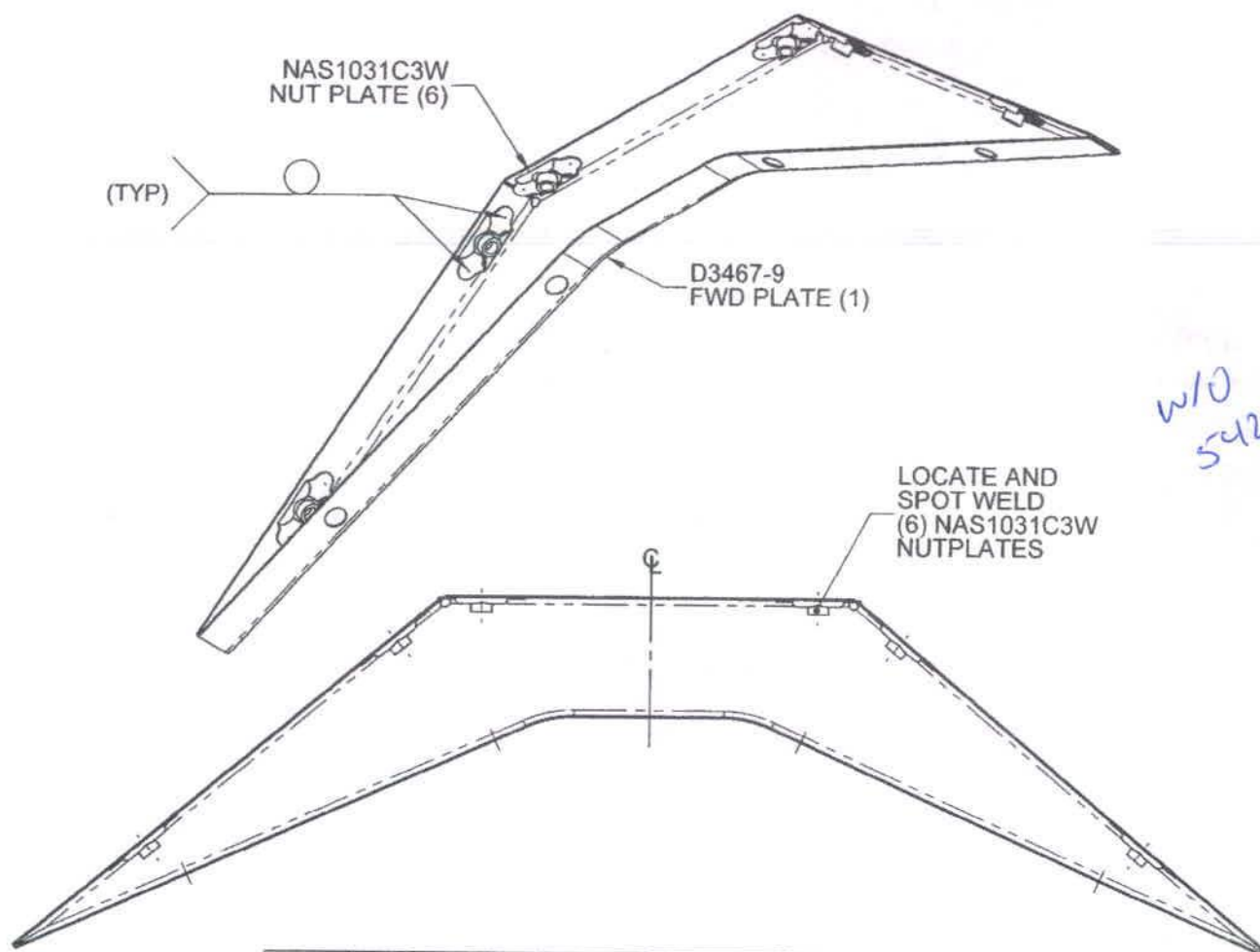
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C
DATE 08.12.19		TITLE SHROUD ASSEMBLY	SHEET 2 OF 15 SCALE 1:2

RELEASED
9/6/30 *[Signature]*



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

D3467-043 FWD PLATE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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1880

1880

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DRAWN BY

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. C

D3467

SHEET 3 OF 15

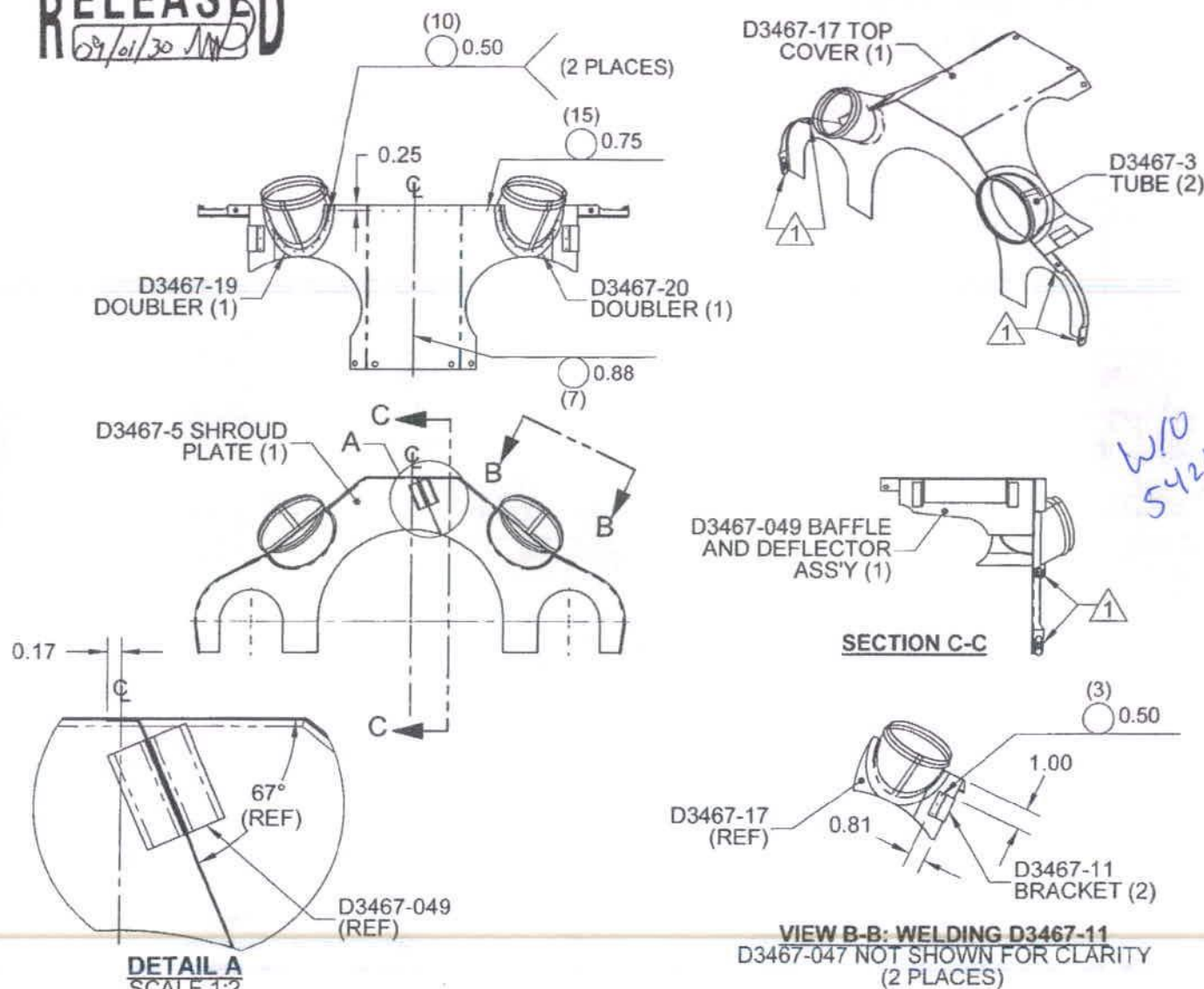
DATE

TITLE

SCALE

08.12.19**SHROUD ASSEMBLY**

1:8

RELEASED
09/01/20**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

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12-18-05

12-18-05

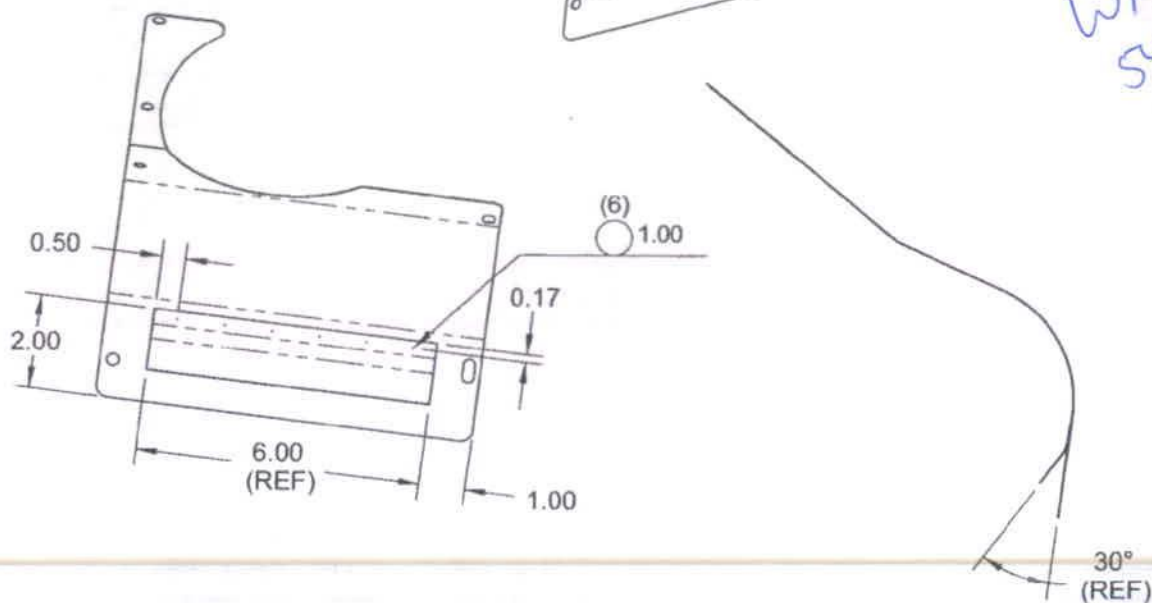
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DATE 08.12.19		TITLE SHROUD ASSEMBLY	SHEET 4 OF 15 SCALE 1:4

RELEASED
07/01/30

D3467-1 COVER
PLATE L/H, SHOWN
(D3467-2 COVER
PLATE R/H, OPPOSITE)

D3467-7
SEAL STRIP (1)



D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

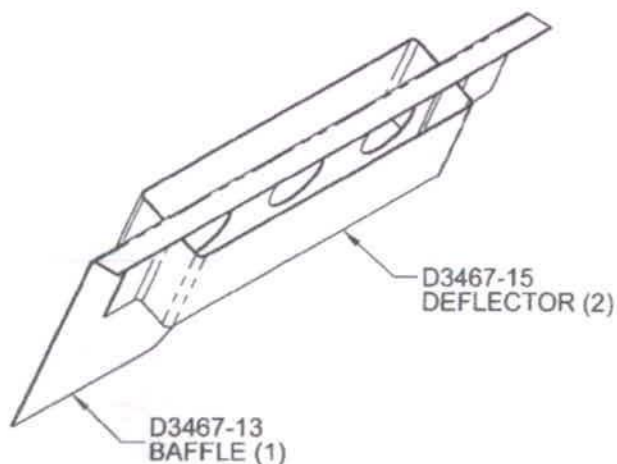
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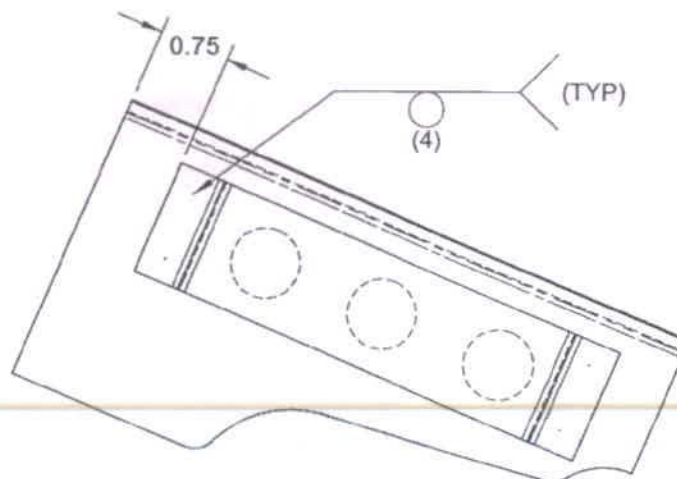
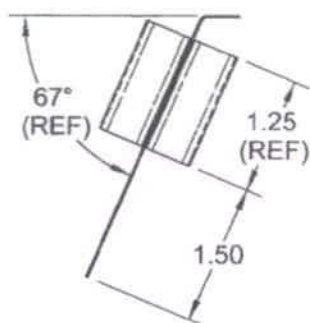


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DATE 08.12.19		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
09/01/30 MB



W/O
54214



D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -049	P/N	DESCRIPTION
X	D3467-049	BAFFLE & DEFLECTOR ASSEMBLY
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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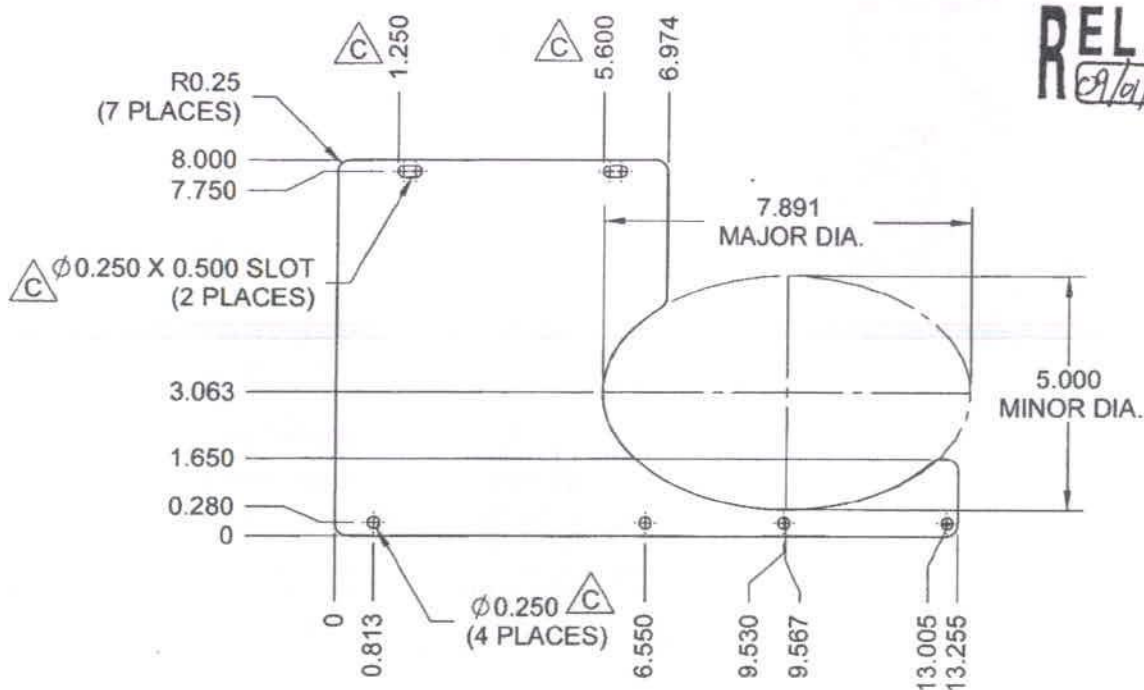
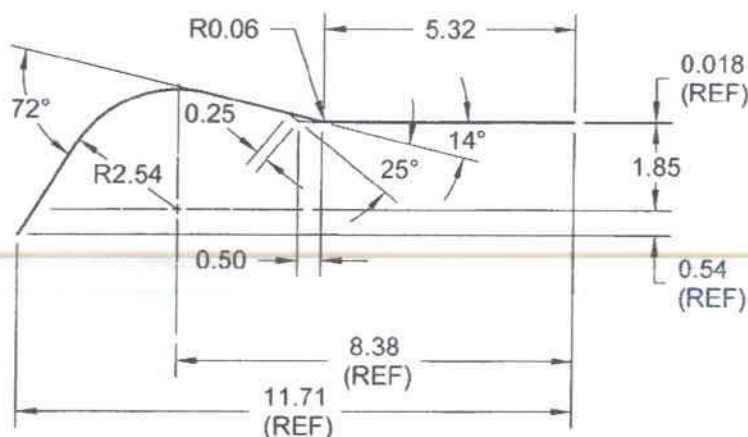
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1000

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DART

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CHECKED <i>Pjt</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C
DATE 08.12.19		TITLE SHROUD ASSEMBLY	SHEET 6 OF 15 SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER PLATE
D3467-2 R/H COVER PLATE (OPPOSITE)****D3467-1 L/H COVER
PLATE ISOMETRIC VIEW.
D3467-2 R/H COVER
PLATE (OPPOSITE)
SCALE 1:8****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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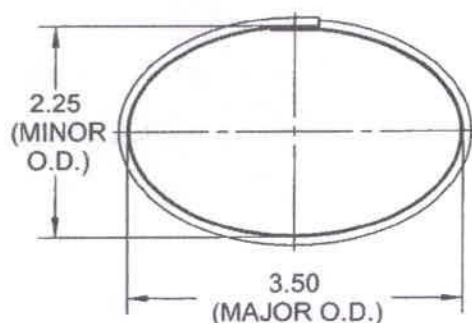
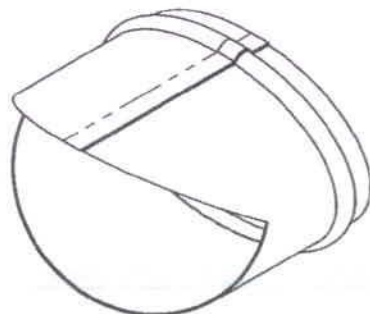
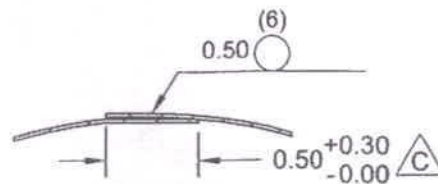
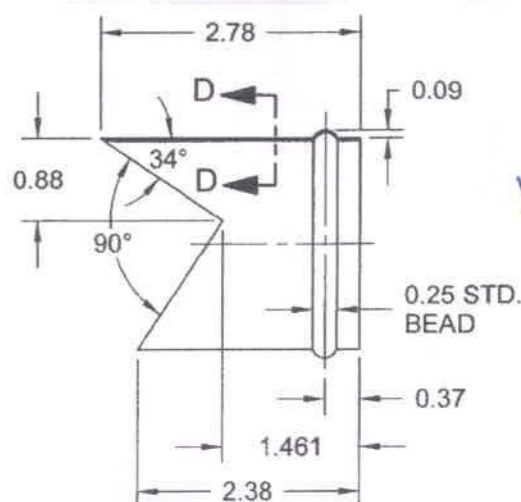
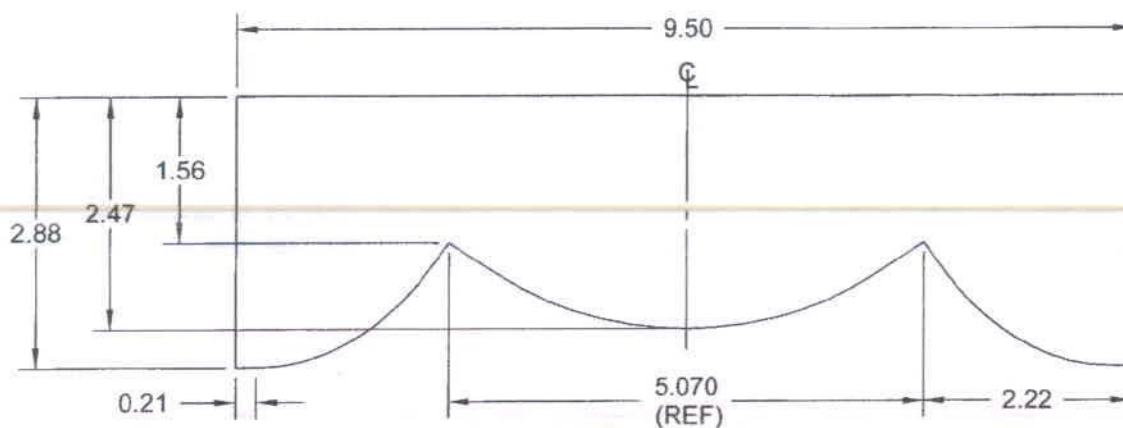
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1912

1912

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C SHEET 7 OF 15
DATE 08.12.19		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
[Signature]**D3467-3 TUBE DETAIL****SECTION D-D**
SCALE 1:1*W10
54214***D3467-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

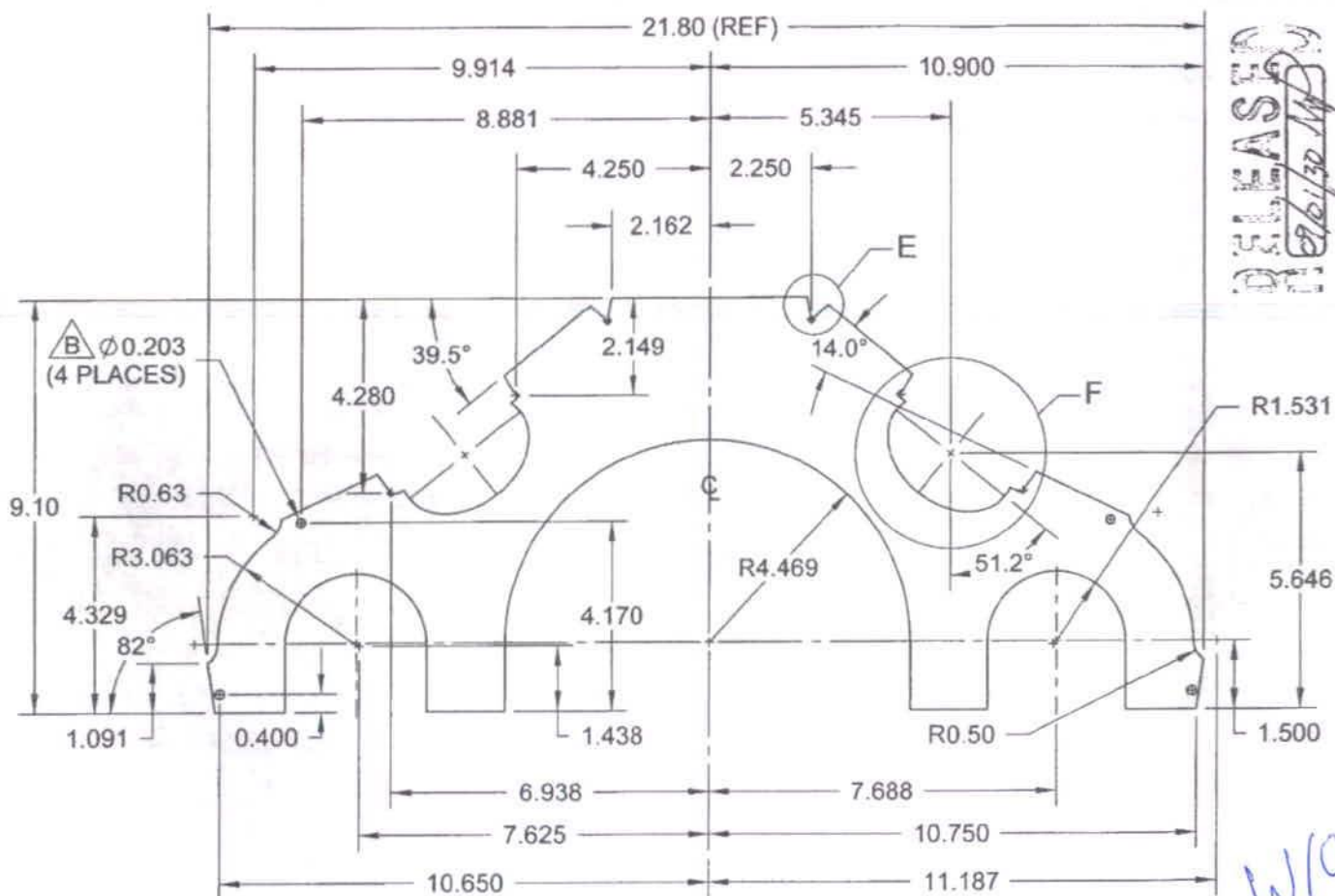
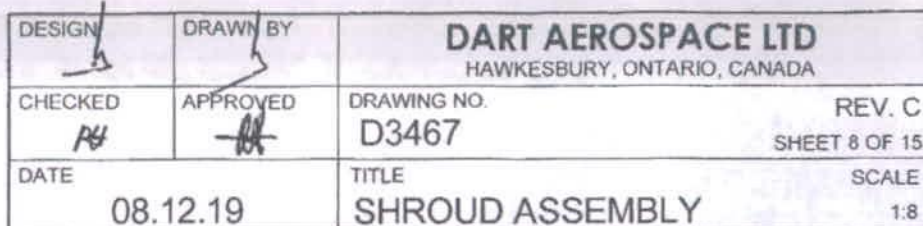
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11-11-11

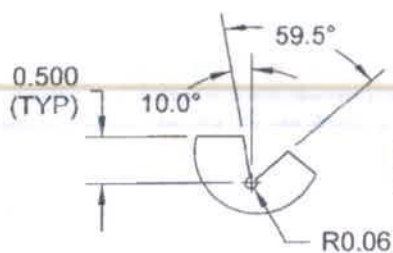
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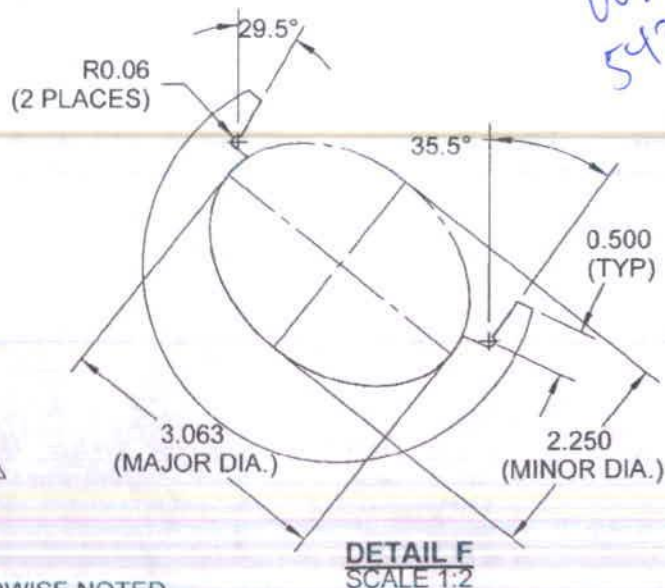


09/01/30 *W*

W/O
54214




DETAIL E
SCALE 1:2



DETAIL F
SCALE 1:2

D3467-5F AFT PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059  (MA.
(ANNEALED) 2B FINISH OR AMS 5513/5524,
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

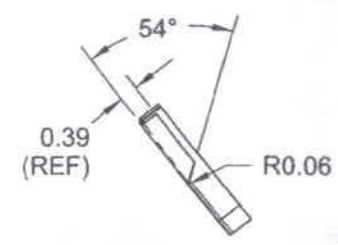
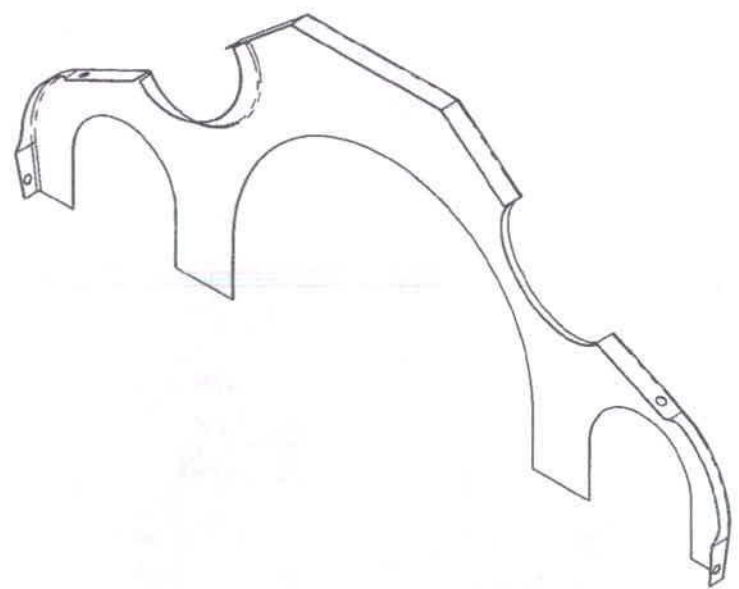
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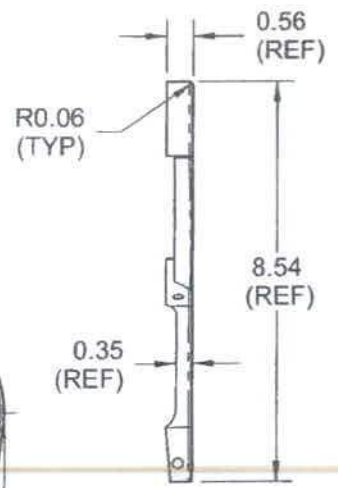
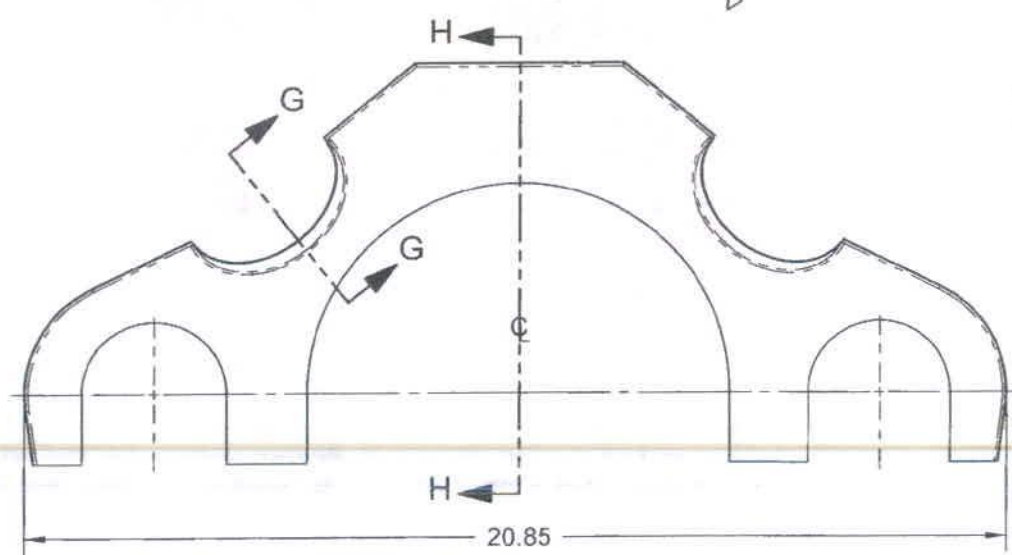


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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C SHEET 9 OF 15
DATE 08.12.19		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED
09/01/30 *[Signature]*



SECTION G-G



SECTION H-H

D3467-5 AFT PLATE BENDING DETAIL
(MAKE FROM D3467-5F)

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

W/O 54214

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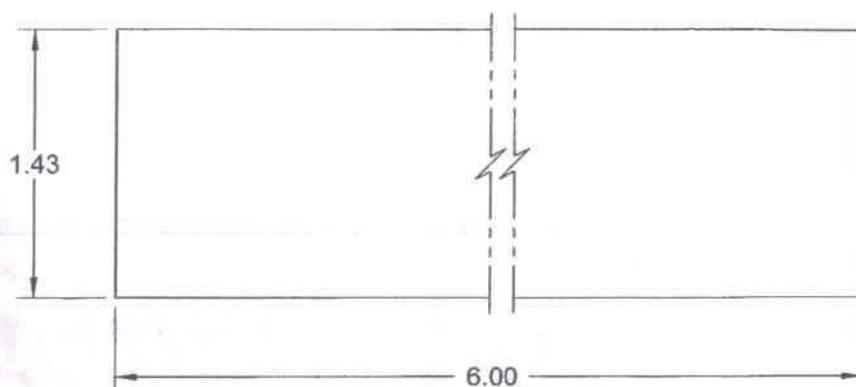
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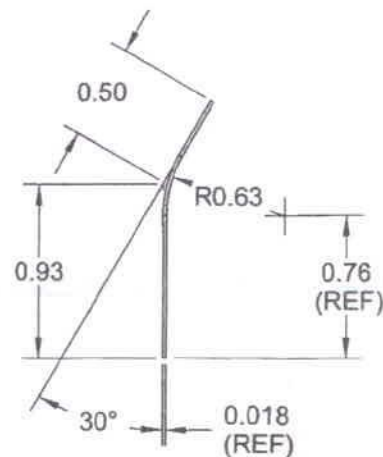
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DART

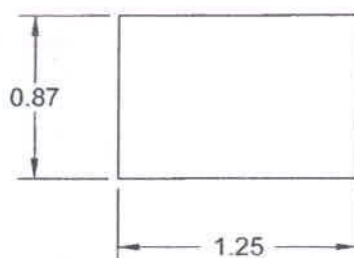
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CHECKED <i>RH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C SHEET 10 OF 15
DATE 08.12.19		TITLE SHROUD ASSEMBLY	SCALE 1:1

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09/01/30 NP

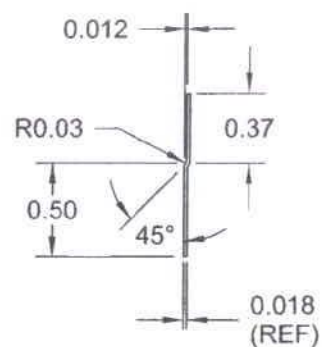
**D3467-7F SEAL STRIP
FLAT PATTERN**



**D3467-7 SEAL STRIP
BENDING DETAIL**



**D3467-11F BRACKET
FLAT PATTERN**



**D3467-11 BRACKET
JOGGLE DETAIL**

*W/O
54214***NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH 
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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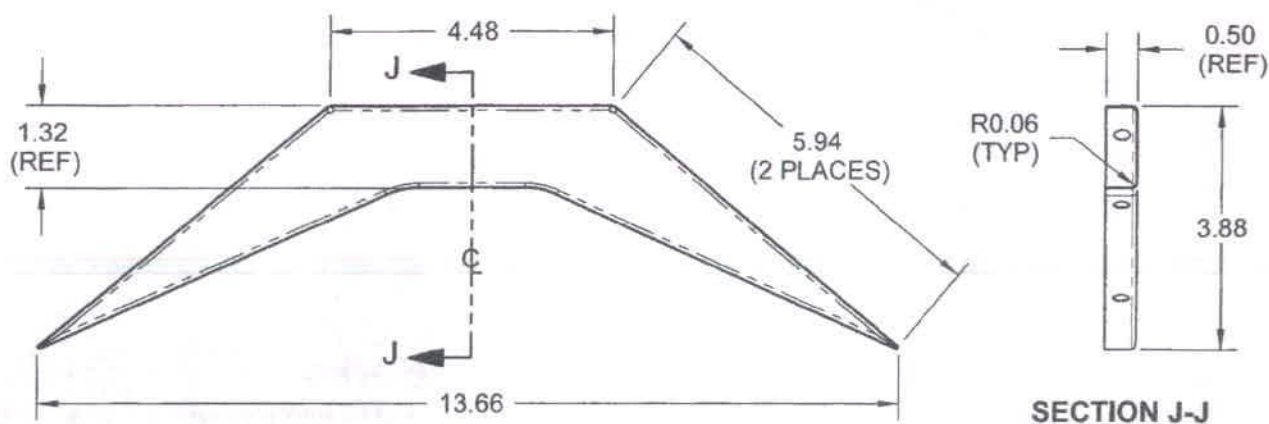
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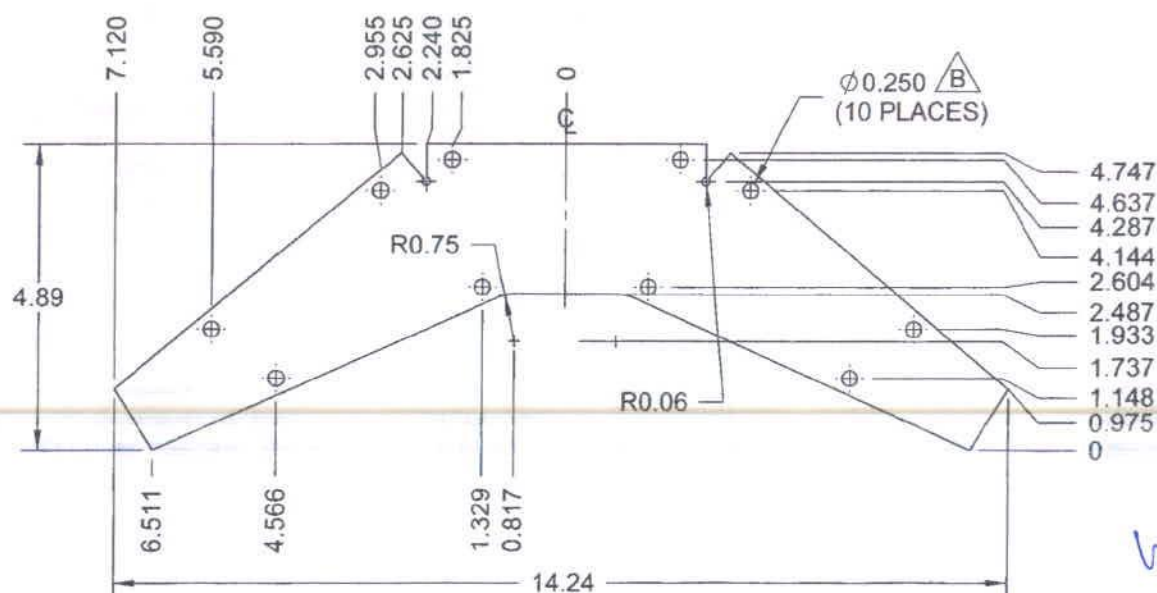


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DATE 08.12.19	TITLE SHROUD ASSEMBLY		SCALE 1:3

RELEASED
09/01/20



D3467-9 FWD PLATE BENDING DETAIL



D3467-9F FWD PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

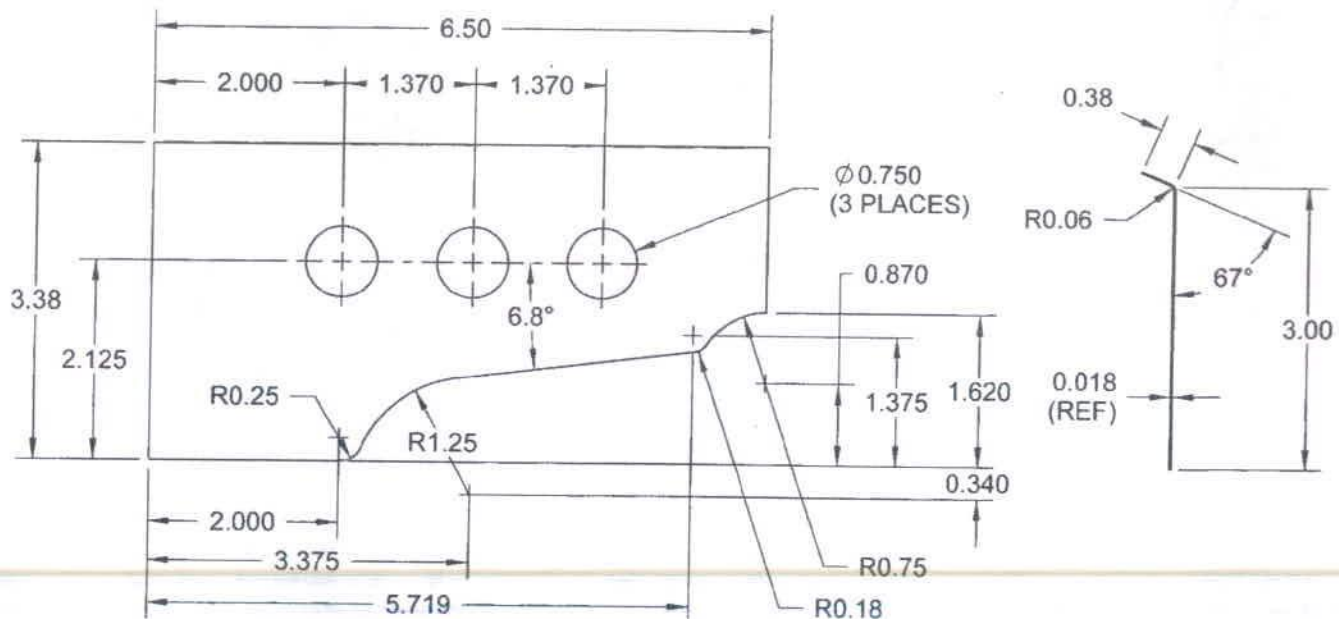
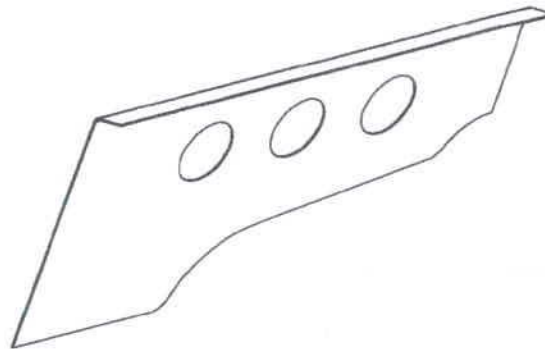
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*W/O
54214*

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C
DATE 08.12.19		TITLE SHROUD ASSEMBLY	SHEET 12 OF 15 SCALE 1:2

RELEASED
09/01/30 M/P**D3467-13F BAFFLE
FLAT PATTERN****D3467-13 BAFFLE
BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH \triangle
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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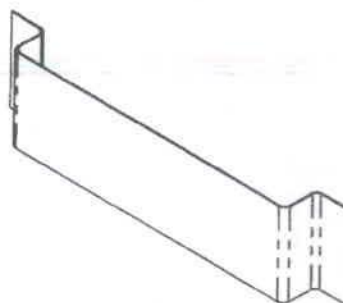
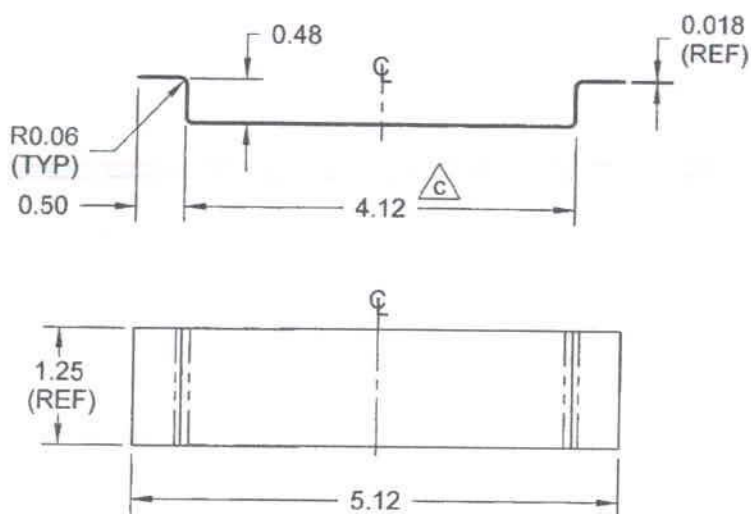
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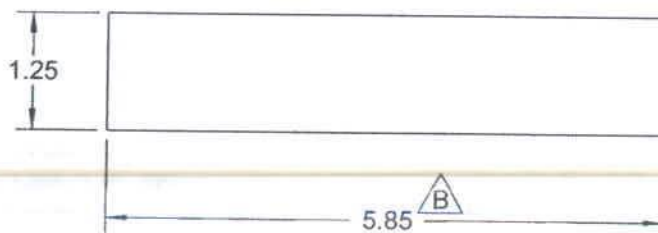


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DATE 08.12.19		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
09/01/30 MJP



D3467-15 DEFLECTOR BENDING DETAIL



W/O
54214

D3467-15F DEFLECTOR FLAT PATTERN

NOTES:

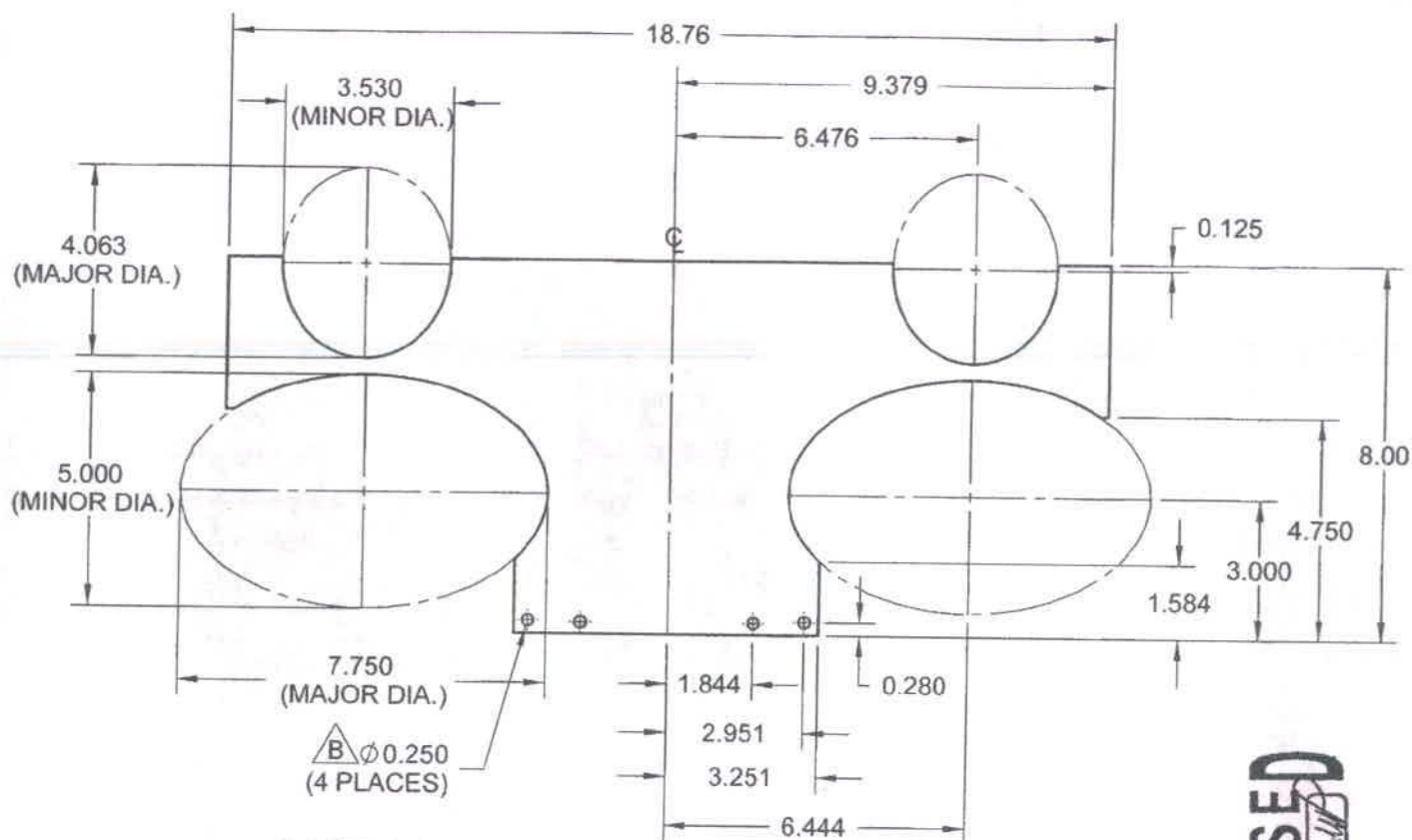
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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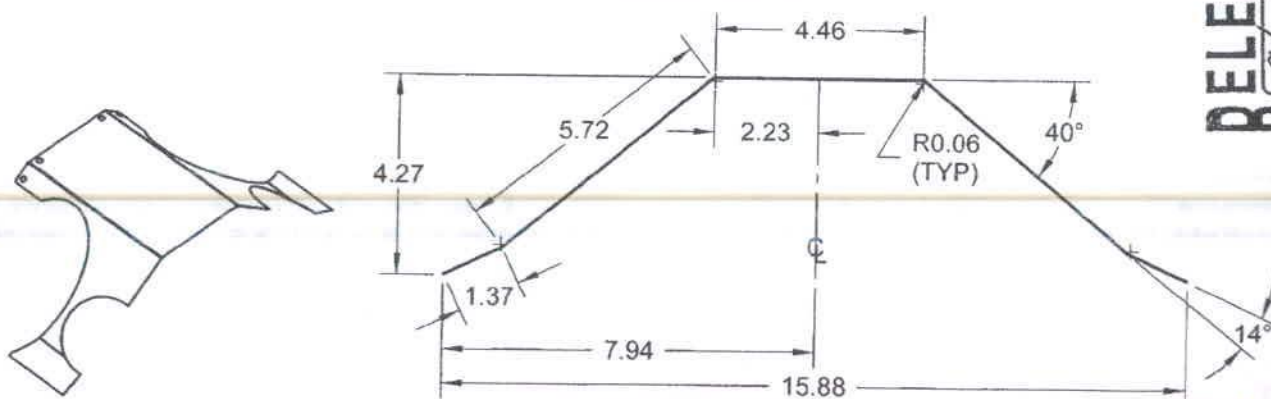
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1933

1933




D3467-17F TOP COVER FLAT PATTERN



D3467-17 TOP COVER BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH 
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W. A. J. L. - 3/5/50 - 10/15/50

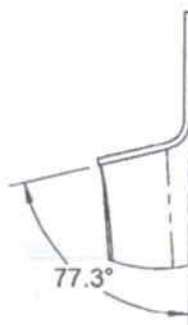
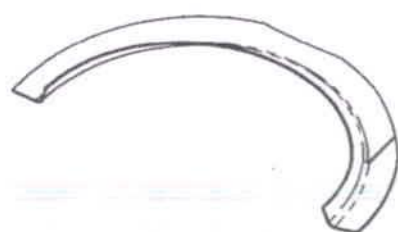
W. A. J. L. - 3/5/50 - 10/15/50

W. A. J. L. - 3/5/50 - 10/15/50

W. A. J. L. - 3/5/50 - 10/15/50

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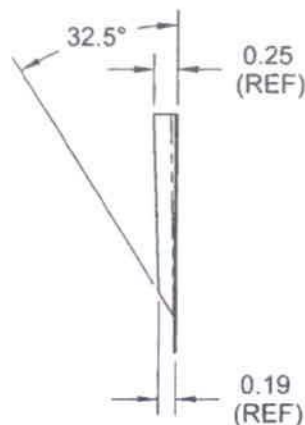
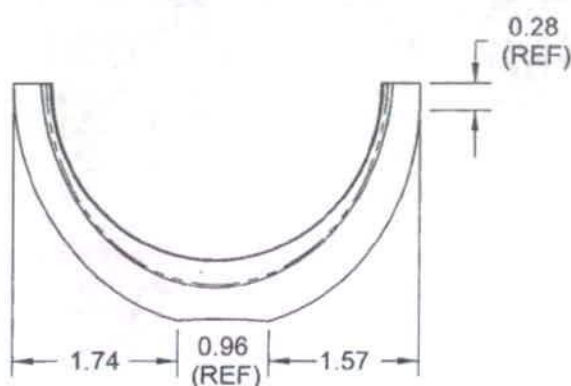
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DATE 08.12.19		TITLE SHROUD ASSEMBLY	SHEET 15 OF 15 SCALE 1:2



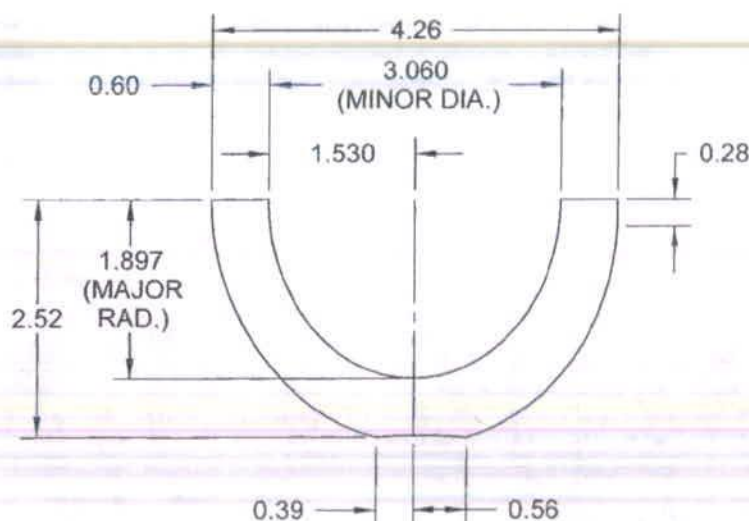
DETAIL K
SCALE 1:2



RELEASED
08/13/2019



D3467-19 DOUBLER, L/H SHOWN
D3467-20 DOUBLER, R/H OPPOSITE



D3467-19F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SHIP TO: Dart Aerospace

1270 Aberdeen Street

Hawks but,

ON

K6A 2H8

PACKING LIST

0871

613-634-5200

DATE MM DD YY		No. OF CARTONS	CARRIER & WAYBILL	PACKED BY
QTY.	DESCRIPTION	PART #	SERIAL #	A
1	Shroud Assembly - Side and Front pieces missing. New Shroud supplied to us on Dist Packing Slip # JNV 100746	D3467-041		
ATTN: Dave				
9/11/10				

